

Work Order ID 133106-1

Tuesday, May 26, 2015 12:44:25 PM

U/R***133106***

Page 1

Item ID: D117-840-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw with Wearplates

Start Date: 5/18/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: MLS Date: MAY 26 2015 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D117-840	B

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D117-840-011

CHG 002

MLS 15-06-15 ②

DAS 38 9-89

15-08-21

160 Pick Kit 0.00

160

Packaging

Packaging

Memo

0.00

2X DAS 27 9-89

JUN 15 2015

DAS 38 9-89

170 QC4- 100% Inspect kits for completeness 0.00

170

QC

Quality Control

Memo

0.00

DAS 38 9-89

15-08-21

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 133106

Tuesday, May 26, 2015 12:44:25 PM

133106

Page 2

Item ID: D117-840-011

Accept

N19000040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw with Wearplates

Stop ***NS2***

Start Date: 5/18/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-840-011								
	Location: <u>Q15</u>								
	PPP Rev: _____								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Ship

[Signature]

SEP 08 2015

DAS 6 288

MCS

SEP 08 2015

[Signature] 20150908



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							

Picklist Print

Tuesday, May 26, 2015 12:44:24 PM

Page 1

Work Order ID: 133106

133106

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 5/18/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-04-01 JLM VERIED BY:DD IPP
REV:B 13.05.28 PER IIN D117-840 REV.A DD VERF:JLM IPP REV:C
15.03.30 PER REV B JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2274

Manufactured No

Each

579.0000

8

16

D2274

Radius Block

DAS
38
9-89

**

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

432

102156

2

106191

46

108466

12

127570

324

128474

36

129934

12

ST012a

135

131031

135

D3456-1

Manufactured No

Each

83.0000

12

24

D3456-1

Washer

DAS
38
9-89

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST051A

76

128456

3

130974

50

132585

23

DAS
27
9-89
JUN 15 2015

B131213
B133136

24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

Tuesday, May 26, 2015 12:44:24 PM

Page 2

Work Order ID: 133106

133106

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 5/18/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

D4012-1 Manufactured No

D4012-1

Cushion

DAS
38
9-89

Location

FG
131213
ST545
131213
132222
132619

Loc Qty

5
5
69
11
18
40

Loc Code

Each 74.0000
~~B133148~~

**

4 8
133458 x4

DAS
27
9-89

DAS
8
9-89

+ 2 B 133458 x2
Eng took 2 for testing

D4796-1 Manufactured No

D4796-1

Bearpaw

DAS
38
9-89

Location

st612
129946
131053

Loc Qty

3
1
2

Loc Code

Each 0.0000

**

B133127

2 4
4

DAS
27
9-89

DAS
8
9-89

D4798-041 Manufactured No

D4798-041

Wearplate Assembly

DAS
38
9-89

Location

st543
131210

Loc Qty

20
20

Loc Code

Each 20.0000

**

2 4
x B 133475

DAS
27
9-89

DAS
8
9-89

D4799-1 Manufactured No

D4799-1

Clamp

DAS
38
9-89

+ 2 B 133710

* eng use 2 for testing

DAS
27
9-89
JUN 15 2015
DAS
16
9-89

Tuesday, May 26, 2015 12:44:24 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																					

Picklist Print

Tuesday, May 26, 2015 12:44:24 PM

Page 3

Work Order ID: 133106

133106

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 5/18/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

AN4C11A Purchased No

AN4C11A

bolt

DAS
38
9-89

Each 49.0000 12 24

**

DAS
27
9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

ST344

49

131677

24

m131957

25

Each

24.0000

**

16

DAS
27
9-89

DAS
8
9-89

AN4C17A Purchased No

AN4C17A

BOLT

DAS
38
9-89

Location

Loc Qty

Loc Code

ST343

24

114523

24

Each

918.0000

**

40

DAS
27
9-89

DAS
8
9-89

MS21043-4 Purchased No

MS21043-4

Nut

DAS
38
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

285

m128798

285

ST304

593

m128818

34

m131697

59

m132382

500

JUN 15 2015

Tuesday, May 26, 2015 12:44:25 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Picklist Print

Tuesday, May 26, 2015 12:44:25 PM

Page 4

Work Order ID: 133106

133106

Parent Item: D117-840-011

D117-840-011

Parent Item Name: Bearpaw with Wearplates

Start Date: 5/18/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

Each

5,690.000

8

16

NAS1149D0463.I

DAS

38

9-89

9-89

WASHER

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

2000

M132317

2000

ST269

3649

M129682

86

M130799

371

M132035

3192

JUN 15 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-840-011	27.7 lb	0.0 in	0.0 lb-in	204.1 in	5653 in-lb
<i>Bearpaw Installation</i>	12.6 kg	0.0 mm	0.0 mm-kg	5200 mm	65,520 mm-kg

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
12	D3456-1	WASHER
4	D4012-1	CLAMP CUSHION
2	D4796-1	BEARPAW
2	D4798-041	WEARPLATE ASSY
4	D4799-1	CLAMP
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
8	NAS1149D0463J	WASHER